	528		*10	852	28*							Page 1
D3161-9 Hinge 17.0"		A	Accept	*	<b>1</b> 900	<b>040</b>	100	)* ፡	Setup	Start Stop	14.	S1* S2*
10/21/13 S	- •	*4* *4*				D:						
								j	Run			R1* R2*
D D	Description		Set Up/ Run Hours	3	Tool ID	Tool#	Plan Code	Accept Qty		_	Reject Number	Insp. Stamp
Revisi	on Nbr											
Rev A	2											
s	Memo	ge makes (4) D3161-9 parts a	0.00 0.00 at 17" longCut to lea	ngth as per l	Dwg			4x	<u></u> _			3/0/23
(	QC5- Inspect part comp	leteness to step on W/O	0.00	27 89				<u>4</u>			and the second of the second o	·
1	Identify as per dwg & St  Memo	tock Location: <u>570</u> 3]	0.00					4 <sub>X</sub>	D 2	AS /c 89	3 <i>-10-</i> 0	23
	1:51:17 PM D3161-9 Hinge 17.0" 10/21/13 10/21/13 Process Plan: QC: Revisi Rev A	Hinge 17.0"  10/21/13 Start Qty: 4.00  10/21/13 Req'd Qty: 4.00  Process Plan: MLD QC: Operation Description Revision Nbr Rev A2  Small Fab  Memo (1) 72" Hing D3161  QC5- Inspect part comp  Memo Identify as per dwg & Si	D3161-9	Date:	D3161-9   Accept   *	D3161-9	D3161-9   Accept	D3161-9   Accept	D3   161-9   Accept   *N900040100*	D3 6 -9   Accept	D3161-9	D3161-9

**36** 9-89

DQA:	Date:		e' 💊	
λάπ.	. Date.			_

NCR: Yes / No

## **WORK ORDER NON-CONFORMANCE / UPDATE**

NCIN.	cs / 140				WORK ORDER NOW			VIAITEL / OI		QA Closed:	Dat	te:		
Work Orde	r:		<u>-</u> -		DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part N					Rework Scrap			Skid-tube Machining	Crosstube Small Fab		Water Jet d. Eng. Coor.	Engineering Quality		
NCR N	0			<del></del>	Use-as-is Work Order Update			noforming Large Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier	Other		
Root				Descri	ption of work order update	Ī	nitial	Ac	tion	Sign &				
Cause	Date	Step	Qty	•			ief Eng	Desc	ription	Date	Verification	n QC Inspector		
Doc/Data														
Equip/Tooling														
Operator														
Material														
Setup										1				
Other														
Process														
Supplier														
Training														
Unapproved														
					F	AUL	T CATE	GORY						
Landin	ng Gear				General					_	_			
	Bending				Bend		Grain			Ovalized		Pressure/Forced		
	Centre No	ot Conce	ntric to C	o/s	BOM/Route		Hardwa	ire		Over/Under	tolerance	Temperature/Cure		
[	Cracks				Broken/Damaged		Inspect	ion Incomplete		Part Incorre	ct	Weld		
	Crushed/	Crimped			Burrs			tions Incomplete/	'Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled		
	Cuffs				Contamination		Mainte	enance		Part Moved				
	Heat Trea	at			Countersink		Mislabe	eled	Γ	Positioned V	Vrong			
	Inspectio	n Strip in	Tube		Cut Too Short		Misrea	d		Power Loss/	Surge	Other		
	Ripples in	es in Bend Drill Holes			Offset		_							
[	Torque W	aves in Extrusion Drawing			Out of	Calibration								
	Turning S	ng Sequence Finish			Out of	Sequence								
	Wave/Tw	ave/Twist in Tube Folio				Outside	Dimensions							

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

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**Quality Control** 

Work Order ID 108528 Page 2 October-17-13 1:51:17 PM Item ID: D3161-9 Accept Setup Start \*N900040100\* **Revision ID:** Stop Hinge 17.0" Item Name: Start Qty: 4.00 **Start Date:** 10/21/13 **Cust Item ID:** Req'd Qty: 4.00 Required Date: 10/21/13 **Customer:** Reference: Run Process Plan: Date: Tooling: Date: \_\_\_\_\_ **Approvals:** Stop QC: \_\_\_\_\_ Date: \_\_\_\_ SPC (Y/N): Date: Reject Sequence ID/ Tool ID Reject Operation Set Up/ Tool # Plan Accept Insp. Number Stamp Code **Work Center ID** Description **Run Hours** Qty Qty QC21- Final Inspection - Work Order Release 0.00 130 \*130\* QC 0.00 Memo

			•	<b>∴</b>
DQA:	Date:			

NCR: Yes / No

## **WORK ORDER NON-CONFORMANCE / UPDATE**

									QA Closed:	Dat	te:			
Work Orde	n <del>ri</del> .				DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part N					Rework Scrap		Skid-tube Machining	Crosstube Small Fab	Pro	Water Jet	Engineering Quality			
NCR N	lo				Use-as-is Work Order Update	The	rmoforming Large Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier	Other			
Root				Descri	ption of work order update	Initial	A	ction	Sign &					
Cause	Date	Step	Qty		or Non-conformance	Chief Er	g Des	cription	Date	Verification	n QC Inspector			
Doc/Data								•						
Equip/Tooling														
Operator														
Material														
Setup														
Other						1								
Process						]								
Supplier [														
Training														
Unapproved														
					F	AULT CA	regory							
Landir	ng Gear				General				_					
	Bending				Bend	Graii	ı		Ovalized		Pressure/Forced			
	Centre N	ot Conce	ntric to (	o/s	BOM/Route	Hard	ware		Over/Under	tolerance	Temperature/Cure			
	Cracks			L	Broken/Damaged	Inspe	ction Incomplete		Part Incorre	ct	Weld			
	Crushed/	Crimped			Burrs	instru	ictions Incomplete	/Unclear	Part Lost/M	issing	Wrong Stock Pulled			
	Cuffs			· <u>L</u>	Contamination	Mair	tenance		Part Moved					
	Heat Trea	at .		L	Countersink	Misla	beled		Positioned V	Vrong ,				
	Inspectio		Tube	L	Cut Too Short	Misre	ead		Power Loss/	'Surge	Other			
•		Ripples in Bend Drill Holes			Offse	t								
	Torque V	Vaves in E	es in Extrusion Drawing			Out of Calibration								
		Sequence Finish			Out	of Sequence								
	Wave/Tw	Wave/Twist in Tube Folio				Outsi	de Dimensions							

## **Picklist Print**

October-17-13 1:51:17 PM

Work Order ID:

108528

Parent Item:

D3161-9

Parent Item Name:

Hinge 17.0"

**Start Date:** 10/21/13

Required Date: 10/21/13

Page 1

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP A04.08.24New IssueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS20257-3-7200 Piano Hinge		Purchased	No			100	f	64.2816	1.65	6.6	13/10	23_	36
				<b>Location</b>		Loc Qty	<u>Lo</u>	c Code			/ ,	/	
				ST209a		64.2815788							
			•	12	3960	2.2447368							
				m1	126275	26.036842			_6,	6			
				m1	127172	36				-			

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									DQA:	Date:		
NCR: Ye	es / No				WORK ORDER NON-	CONFOR	MANCE / UP	DATE	QA Closed:	Date:		
Work Order	:			<u></u>	DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Part No	D	Rework Scrap Use-as-is Work Order Update					Skid-tube  Machining  moforming  Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet od. Eng. Coor. re/Packaging Supplier	Engineering Quality Other	
Root Cause	Date	Step	Qty		ption of work order update or Non-conformance	Initial Chief En	į.	ction	Sign & Date	Verification	QC Inspector	
oc/Data quip/Tooling Derator Material etup Other rocess upplier raining												
						FAULT CAT	EGORY					
Landing	g Gear				General		•		_		_	
	Bending Centre N Cracks Crushed/ Cuffs Heat Tred Inspection Ripples in	Crimped at on Strip in n Bend	Tube		Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing	Instruction Maint Mislate Misree Offset	tion Incomplete ctions Incomplete/ cenance peled ad	/Unclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned \ Power Loss/	ct issing ·	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other	
<u> </u>	Turning 9						Sequence					

Outside Dimensions

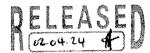
Wave/Twist in Tube

Folio

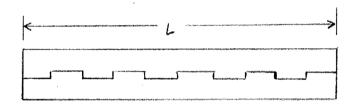




DES	GN #	DRAWN BY	DART AEROSPACE HAWKESBURY, ONTARIO, CAN		)	
CHE	CKED FAT	APPROVED	D3161	SHEET	REV.	, .
DATE	02.04	. 24	TITLE HINGE			ITS
A	07	1.04.24	NEW ISSUE			
AI	11	04.02.27	ADDED D3161-5			
AZ	PA	04.06 30	ADD 03161-7 & 03161-9	******************	~*************************************	



P/N_	LENGTH 'L'	DESCRIPTION
D3161-1	13.5"	HINGE (REPLACES MS 20257-3-13.5 ON DZ183)
D3161-3	15.0"	HINGE (REPLACES MS 20257-3-150 ON D2950-041)
D3161-5	9,9"	HINGE
03161-7	14,5"	HINGE
03161-9	17.6	HINGE



## NOTES:

1) MAKE FROM MS20257-3-7200 HINGE